

Work Order ID 73985

Tuesday, September 20, 2011 10:24:25 AM



Page 1

Item ID: D2842-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly, 206 Float

Start Date: 9/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 10/4/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *11-09-20*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2842

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
2-Drill D2842-1 using Jig DT8271 as per Dwg-D2842
3-Deburr and bevel ends for welding

11.10.08

2



110

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

11.10.12

2



120

0.00



Weld per dwg A/R Aluminum rod Batch: *114514*

Large Fab

Memo

0.00

Large Fab

1-Weld one end cap and (2) lugs using Jig DT followed by DT as per
Dwg D2842

2-Grind end cap weld flush

11.10.13

2



73985

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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2	0	11/10/11	
170 Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: 114514 Large Fab Memo 1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.	0.00 0.00				2	0	11.10.18	
180 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				2	0	11/10/19	

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Required Date:	10/4/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>Suksha</i>		<i>2</i> <i>4</i>			
191 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo ***Touch up step with alodine per qsi 005 prior to powder coat***	0.00 0.00				<i>2</i>	<i>BR</i>	<i>11-10-19</i>	
200 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: <i>9:30</i> OVEN TEMPERATURE: <i>320°F</i> FINISH TIME: <i>10:00</i>	0.00 0.00							<i>2x ✓ M-L 11/10/19</i>

M 117745

W/O:		WORK ORDER CHANGES					
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Start Date:	9/20/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	10/4/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 	QC3- Inspect Part Finish	0.00				2		BL 11-10-19.	
QC Quality Control	Memo	0.00							
220 	HandFinishing	0.00				2		BL 11-10-20.	
HandFinish Hand Finishing	Memo 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch <u>M118988.</u>	0.00							
230 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							<u>Sublot 20</u> <u>44</u>

W/O:		WORK ORDER CHANGES						
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Cust Item ID:

Required Date: 10/4/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PCC73983

0.00

Packaging

P4/10/23 @

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/27

CMF 11-10-26

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, September 20, 2011 10:24:22 AM

Page 1

Work Order ID: 73985

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float



Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960C10L * R NAS1149C0332 ✓ Purchased

No

100

Each

0.0000

3

6



washer

118354.



6. BL 11-10-20.

D2622-120C

Manufactured

No

120

Each

145.2000

1

2



Step Extrusion



BL 11.10.13

Location

Loc Qty

Loc Code

HALL

135.5

64409

6

68293

22.5

72131

107

WA

9.7

46910

2

66970

7.7

2

D2734

Manufactured

No

120

Each

46.0000

2

4



Step End Plate



BL 11.10.13

Location

Loc Qty

Loc Code

WA

46

70701

5

73196

41

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 73985

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 2.00

Required Qty: 2.00

D3459-3 Manufactured No

120 Each

27.0000 2 4



Float Step Mounting Plate



11.10.13

Location

Loc Qty

Loc Code

ST017

5

62956

5

WA

22

73320

22

4

D3459-1 Manufactured No

220 Each

16.0000 2 4



Float Step Mounting Plate



11.10.13

Location

Loc Qty

Loc Code

WA017

16

73319

16

4

MS27039C1-07 Purchased No

220 Each

54.0000 3 6



screw



BR 11-10-20.

Location

Loc Qty

Loc Code

ST293

54

117423 ✓

29

118686

25

6

NAS1329C3KB130 Purchased No

220 Each

28.0000 3 6



insert



BR 11-10-20.

Location

Loc Qty

Loc Code

ST276

28

117679 ✓

28

6

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 73985

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1515H3L

Purchased

No

220

Each

160.0000

3

6



WASHER

BR 11-10-20

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

120

113362

57

118686 ✓

63

6,

Tuesday, September 20, 2011 10:24:23 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

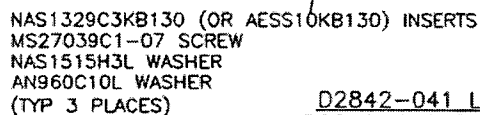
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. B
CHECKED 	APPROVED 	DRAWING NO. D2842	SHEET 1 OF 1	
DATE 05.09.23	TITLE 206L/407 FLOAT STEP ASSEMBLY		SCALE NFS	
A	98.10.13	NEW ISSUE		
B	05.09.23	RE-DESIGN, ADD D3459-1/-3		



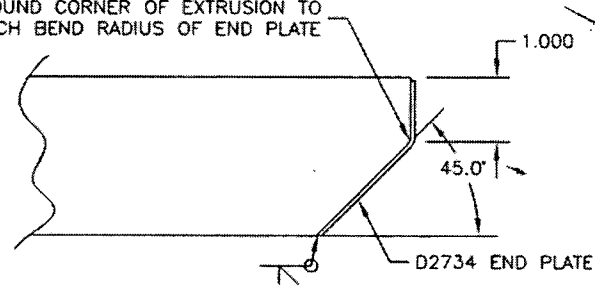
D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AE5S10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN950C10L	WASHER

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
85-11-14 *[Signature]*

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